Work Orde		839		*908			Page 1		
Revision ID: Item Name:	D412-705-01	access Panel	A	Accept	*N900	04010 0) *	Setup Start Stop	14771
Start Date: Required Date:	10/01/12 10/12/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:			
Reference:									
Approvals:	Process Pla	n: MLJ	Date: 12-10-0)	Tooling:	D:	ate:	F	Run Start	*NR1*
	QC:		Date:	SPC (Y/N):	Da	ate:		Stop	*NR2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Rev	ision Nbr							
D3255	Rev	В			7 *				
1 \\ \n^ \\ DC \\ \nocument Control		DOCUMENT CONTRO Memo Photocopy b	OL oluefile & type labels per PPP	0.00 PAS 0.00 PAS 0.00 PAS 0.00 PAS 0.00 PAS) 17 (ω(3 (CHG001		4	dol m	U 12-10-30
110 **110* Packaging Packaging		Pick Kit Memo		0.00			(4] (<u>4/10/3</u>	0 (2)
120 *120* oc		QC4- 100% Inspect kits	for completeness	0.00	nlobj		0	:=====================================	
Quality Control		Memo		0.00					

NCR:	Yes /	No									
Work Order:											
Par	t No.										

DQA:

Date:

NCR: Y	es / No				WORK ORDER NON-O	CONI	FORM	MANCE / UP	DATE				
										QA Closed:	Date	<u>:</u>	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	`	
					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering	
Part No. Scrap Machining Small								Small Fab	-	d. Eng. Coor.	Quality		
					Use-as-is	<u> </u>	Thermoforming Finishing			Rec/Stor	e/Packaging	Other	
NCR No.					Work Order Update	┚┃		Large Fab	Composite	_	Supplier		
Root				Descri	ption of work order update	Ini	itial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data								·					
quip/Tooling													
Operator													
Material	_					1							
etup	_										A		
Other	_					1							
rocess	_												
Supplier	_												
raining	4												
Jnapproved	_ !							6057					
					· · · · · · · · · · · · · · · · · · ·	AULT	CATE	GORY					
Landin	g Gear				General Bend		Grain			Ovalized	Г	Pressure/Forced	
}	Bending	lot Conce	mtuin to 1)/s	BOM/Route	\vdash	araiii Iardwa	·ro	-	Over/Under	toloranco	Temperature/Cure	
}	Cracks	lot Conce	ntric to t	^{5/3} -	Broken/Damaged	\mathbf{H}		ion Incomplete	-	Part Incorre		Weld	
ŀ	_	/Crimped		-	Burrs	\vdash	-	ion incomplete/	/Uncloar	Part Lost/M	}	Wrong Stock Pulled	
-	Cuffs	Crimpeu	-		Contamination	\vdash		enance	Officieal	Part Moved	issuig [Wrong Stock Fulled	
-	_	at		-	-	\vdash	viairite Vislabe		_	Positioned \	Mrong		
	Heat Treat Countersink Inspection Strip in Tube Cut Too Short					\vdash	viisiabe Viisread		 -	Power Loss/		Other	
}	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes					-	viisread Offset	,	L_	Trower ross/	Juige [Tottlei	
}	Torque Waves in Extrusion Drawing							Calibration					
}								Sequence					
}	Turning Sequence Finish							•					
1	Wave/Twist in Tube Folio						Outside Dimensions						

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Work Ord						Page 2						
Item ID: Revision ID:	D412-705-	017		Accept	*N900	040	10	n *	Setup	Start	*N	S1*
Item Name:	N1 Gearbox	Access Panel								Stop	*N	S2*
Start Date: Required Date:	10/01/12 : 10/12/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:	ID:						12
Reference:			- 27									
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:]	Run	Start	I <i>Л</i>	R1*
	QC:		Date:	SPC (Y/N):	D			Stop	*N	R2*		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
130		Packaging		0.00				(2)			12	10/3150
Packaging		Memo		0.00				(29)		·	131	1013/34
Packaging		Identify and 017Location	pack for shipping as per a: PPP Re									!
140		QC21- Final Inspection -	· Work Order Release	0.00							1 1	1'-10
1 4 0		140								12	160 [3194
QC Quality Control		Memo		0.00				-		′		

N12-10-31

												DQA:	Da	te:	
NCR:	/es	/ No				WORK ORDER NON	-CO	NFOR	MANCE / UPI	DATE		•	7	•	•
									:			QA Closed:	Da	ite:	
Work Orde	or.					DISPOSITION				AGAINST [DEF	PARTMENT	PROCESS		*
WOIK Olde	-1.					Rework	7		Skid-tube	Crosstube	\neg		Water Jet		Engineering
Part N	No.					Scrap				Small Fab		Pro	d. Eng. Coor.	-	Quality
						Use-as-is	' "					Rec/Stor	e/Packaging	П	Other
NCR 1	٧o.					Work Order Update			Large Fab	Composite			Supplier		
							<u>.</u>				_				
Root					Desc	cription of work order update		Initial	1	tion		Sign &	_		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desci	ription		Date	Verificatio	n	QC Inspector
Doc/Data		:													
Equip/Tooling															
Operator															
Material															
Setup					- 5				ŀ						
Other 1		*			' •										
Process										•					
Supplier									(i)	• `					
Training															
Unapproved															
						(6)	FAU	LT CATE	GORY						
Landi	ng (Gear			_	General		_		_		_			-
		Bending				Bend		Grain				Ovalized		L	Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route		Hardwa	are			Over/Under tolerance			Temperature/Cure
		Cracks	Cracks Broken/Damaged					Inspection Incomplete				Part incorrect			Weld
	Crushed/Crimped. Burrs						Instructions Incomplete/Unclear P				Part Lost/Missing			Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved
Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Picklist Print

October-01-12 7:43:13 AM

-Work Order ID:

90839

Parent Item:

D412-705-017

Parent Item Name:

N1 Gearbox Access Panel

Start Date: 10/01/12

Required Date: 10/12/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:C Removed Manufacturing 06-08-02 JLM IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty	Qty_ Issued	Date Issued	Status
AN3C3A Bolt		Purchased	No			120	Each	294.0000	30	60	12214	1.0	Z SX
				Location		Loc Qty	<u>1</u>	oc Code					
				GA		62							`
				118	3352	62							
				ST350		232			-				
				120	0187	1			-				
				122	2141	231			12				1
D3255-041 Access Panel Assembly		Manufactured	No			120	Each	3.0000	1	21	8610	8/	
				Location		Loc Qty	<u>1</u>	oc Code					•
				ST176		3							
				861	108	3							الح
D3255-042 Access Panel Assembly		Manufactured	No			120	Each	2.0000	1	2 -	90404		
				Location		Loc Qty	<u>1</u>	oc Code			′ /	C	
				ST176		2							
				788	330	i			-				0
				861	02	1							
MS20427M3-3 Rivet		Purchased	No			120	Each	229.0000	36	72	-/	// 	1/0/30
				Location		Loc Qty	L	oc Code					
				GA		214				•			
				121	114	214			12	1114			
				ST318		3			~	/			
				120	930	3							
				ST335		12							
				123	021	12							

									DQA:	Date:		
NCR: Ye	s / No				WORK ORDER NON-C	CONFOR	MANCE / UP		QA Closed:	Date:	ţ	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
					Rework		Skid-tube	Crosstube		Water Jet	Engineering	
Part No	L				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1 1	noforming	Finishing	Rec/Sto	re/Packaging	Other	_
NCR No	٠.	•			Work Order Update	1	Large Fab	Composite		Supplier		
						.						
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspect	or
Doc/Data												
Equip/Tooling							1					
Operator		1									1	
Material												
Setup												
Other												
Process												
Supplier												

Landing G	iear	General		_		 _
	Bending	Bend	Г	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped_	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Г	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		 -
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence Finish			Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

FAULT CATEGORY

Training Unapproved

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Picklist Print

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-Work Order ID:	90839							
Y Parent Item:	D412-705-017					Start	Date: 10/01/12	Required Date: 10/12/12
Parent Item Name:	N1 Gearbox Access Panel					Start	Qty: 2.00	Required Qty: 2.00
MS21060-L3K Nut Plate	Purchased	No		120	Each	139.0000	18	36 /13 250 Ce S
			Location	Loc Oty		Loc Code		
			316	42				
			122814	42				
			ST303	95				
			120142	95				_
			ST319	2				_
			122141	2				
MS9321-09 Washer	Purchased	No		120	Each	510.0000	30	60 - ////30(
			Location	Loc Qty		Loc Code		
			ST296	510				
			119546	50				_
			120142	2				_
			121524	1				<u>-</u> ,
			122141	457			12214	<u>/</u>

											DQA:	Date:			
NCR:	Yes	/ No				WORK ORDER NON-C	WORK ORDER NON-CONFORMANCE / UPDATE								
											QA Closed:	Date:	• -		
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	`		
Work Orde	٠					Rework		Skid-tube Crosstube	Water Jet	Engineering					
Part N	Vo.					Scrap	1	1	Machining Small Fab	\vdash	Prod	d. Eng. Coor.	Quality		
						Use-as-is	1 1		noforming Finishing	-		e/Packaging	Other		
NCR I	No.					Work Order Update]		Large Fab Composite			Supplier			
				Γ	T 6 .		_		A .A.:		C: 0				
Root					1	ption of work order update	1	nitial	Action		Sign &	\/ - u !£ : + : - u	OC Inconstan		
Cause		Date	Step	Qty	· · · · · ·	or Non-conformance	Chi	ef Eng	Description		Date	Verification	QC Inspector		
Doc/Data	Щ														
Equip/Tooling	Н														
Operator															
Material															
Setup	Н														
Other															
Process	Н														
Supplier	\vdash														
Training	\vdash														
Unapproved	<u> </u>	<u> </u>	<u>. </u>		<u> </u>	F	<u>.</u> Δ111	T CATE	GORY			L			
Landi	ng (Gear				General	7.02		-						
		Bending				Bend		Grain			Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S BOM/Route						\vdash	Hardwa	ire		Over/Under	tolerance	Temperature/Cure		
	Cracks Broken/Damaged												Weld		
	-					Burrs	-		tions Incomplete/Unclear		Part Lost/Mi	<u> </u>	Wrong Stock Pulled		
	Cuffs Contamination						Maintenance Part Moved						_ ~		
	$\boldsymbol{\vdash}$					Countersink	\vdash	Mislabe			Positioned V	Vrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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